

Date: Friday, 05/09/2008 10:07:15 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	205 BEARPAW INSTALLATION KIT (48")
Job Number :	41855	Part Number :	D205564011
Estimate Number :	12283	Drawing Number :	D2521
P.O. Number :		Project Number :	N/A
This Issue :	05/09/2008	Drawing Revision :	J
Prsht Rev. :	NC	Material :	
First Issue :	1/1	Due Date :	30/09/2008
Previous Run :	40082	Type :	MACHINED PARTS
Written By :		Qty:	8 Um: Each
Checked & Approved By :	JLD 08.9.05		
Comment :	Est F 00.01.20 Changed pick list, MPP 2019, CHG006 EC Est Rev:G 06-08-28 As per Rev E JLM Est Rev:H 08-01-11 Added Step #2 JLM Verified BY:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JLD 08.9.24



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D205-564-011 CHG008

08/10/07

2.0	MFG ENGINEERING	MFG ENGINEERING
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Comment: MFG ENGINEERING

Program Batch Number

JLD 08.09.19

3.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 13.6500 sf(s)/Unit Total: 109.2000 sf(s)

blank: 19.500" x 48.0" x 1.00" thick (+0.030/-0.000) per DSK086-6

Material: Black UHMW 1"

(MUHMWB10)

Batch: M108645

RQ 08/10/01

P10

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

(2) Bearpaws Make (1) kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2521 Identify as D2521

3-Deburr

H.A 08/10/02

RQ 08/10/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D205-564-011 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/10/02
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>41855</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/10/02</u>		<u>Control chamber too deep. offset from previous bear paw set up not the same. - R.P</u>	<u>CP</u> <u>08.10.02</u> <u>per</u> <u>08/10/02</u>	<u>Removal Ridge caused by chamber being too low.</u>	<u>D.A</u> <u>08/10/02</u>	<u>per</u> <u>08/10/02</u>	<u>CP</u> <u>08.10.02</u> <u>per</u> <u>08/10/02</u>	<u>S</u> <u>08/10/02</u>

NOTE: Date & initial all entries

Date: Friday, 05/09/2008 10:07:15 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 BEARPAW INSTALLATION KIT (48")

Job Number: 41855

Part Number: D205564011

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

28 08/10/01 *MA 08/10/02*

6.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

28 08/10/05 *75120*

7.0	D2182B	Rubber Cushion
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Comment: Qty.: 3.7000 f(s)/Unit Total: ~~29.6000~~ f(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2182B055 Rubber Cushion

39986

28 08/10/02 *(X7)*

8.0	D2274	Radius Block
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Comment: Qty.: 20.0000 Each(s)/Unit Total: ~~160.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 D2274 Radius Block

B39238

28 08/10/07 *(X7)*

9.0	D2529	Washer
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Comment: Qty.: 20.0000 Each(s)/Unit Total: ~~160.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 D2529 Washer

38188

28 08/10/07 *(X7)*

10.0	D2947	Clamp
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Comment: Qty.: 8.0000 Each(s)/Unit Total: ~~64.0000~~ Each(s)

Clamp

Pick:

Qty Part Number Description Batch

8 D2947 Clamp

B36826

28 08/10/07 *(X7)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 05/09/2008 10:07:15 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 BEARPAW INSTALLATION KIT (48")

Job Number: 41855

Part Number: D205564011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D3544041

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total: ²⁸~~32~~ 0000 Each(s)

CLAMP

Batch:

408361 X17 3508814 3096014

4190513

JS 08/10/07 (X7)

12.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: ⁵⁶~~64~~ 0000 Each(s)

Bolt

Batch:

M109282

JS 08/10/07 (X7)

13.0

AN415A

Bolt



Comment: Qty.: 20.0000 Each(s)/Unit Total: ¹⁴⁰~~160~~ 0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 AN4-15A

Bolt

M108077

JS 08/10/07 (X7)

14.0

AN960JD416

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total: ¹⁴⁰~~160~~ 0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 AN960JD416

Washer

M108827

JS 08/10/07 (X7)

15.0

MS21042L4

Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total: ¹⁴⁰~~160~~ 0000 Each(s)

Nut

Batch:

M108145

JS 08/10/07 (X7)

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

JS 08/10/07 (X7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 05/09/2008 10:07:15 AM
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Job Number: 41855

Part Number: D205564011

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Rev C

50

KS 08/10/07

(7)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.12.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 41855
Description: Bearpaw		Part Number: D2521
Inspection Dwg: D2521	Rev: J	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	.260				
B	0.90	0.96	.950				
C	0.27	0.330	.300				
D	0.470	0.530	.500				
E	21.740	21.760	21.750				
F	0.72	0.780	.750				
G	0.35	0.410	.380				
H	11.490	11.570	11.500				
I	3.41	3.47	3.400				
J	11.790	11.810	11.800				
K	9.47	9.53	9.500				
L	7.190	7.210	7.200				
M	6.910	6.970	6.94				
N	44.47	44.530	44.50				
O	6.590	6.650	6.62				
P	0.940	0.980	.960				
Q	18.97	19.03	19.00				
R	0.350	0.410	.38				
S	0.740	0.780	.755				
T	0.240	0.280	.270				
U	0.370	0.410	.380				
V	0.740	0.780	.760				
W	0.740	0.780	.766				

Measured by: DEJ / H.A. & 1002	Audited by: S.P.	Prototype Approval:	N/A
Date: 05/10/01	Date: 08/10/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM	

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2521	REV. J SHEET 1 OF 3
DATE 06.07.28	TITLE 205 BEARPAW		SCALE NTS
A	95.11.28	NEW ISSUE	
B	96.01.11	SHOW BENDING MOVE HOLES	
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING	
D	96.05.14	ADJUSTED BEAR PAW THICKNESS	
E	96.12.18	43.500 WAS 46.750	
F	97.05.07	ADDED REAR POCKET, MOVED HOLES	
G	98.08.06	ADD C'BORE AND CHAMFER EDGES	
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.	
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES	
J	06.07.28	CHANGE FOR FLOAT SKIDTUBE	

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41855

RELEASED

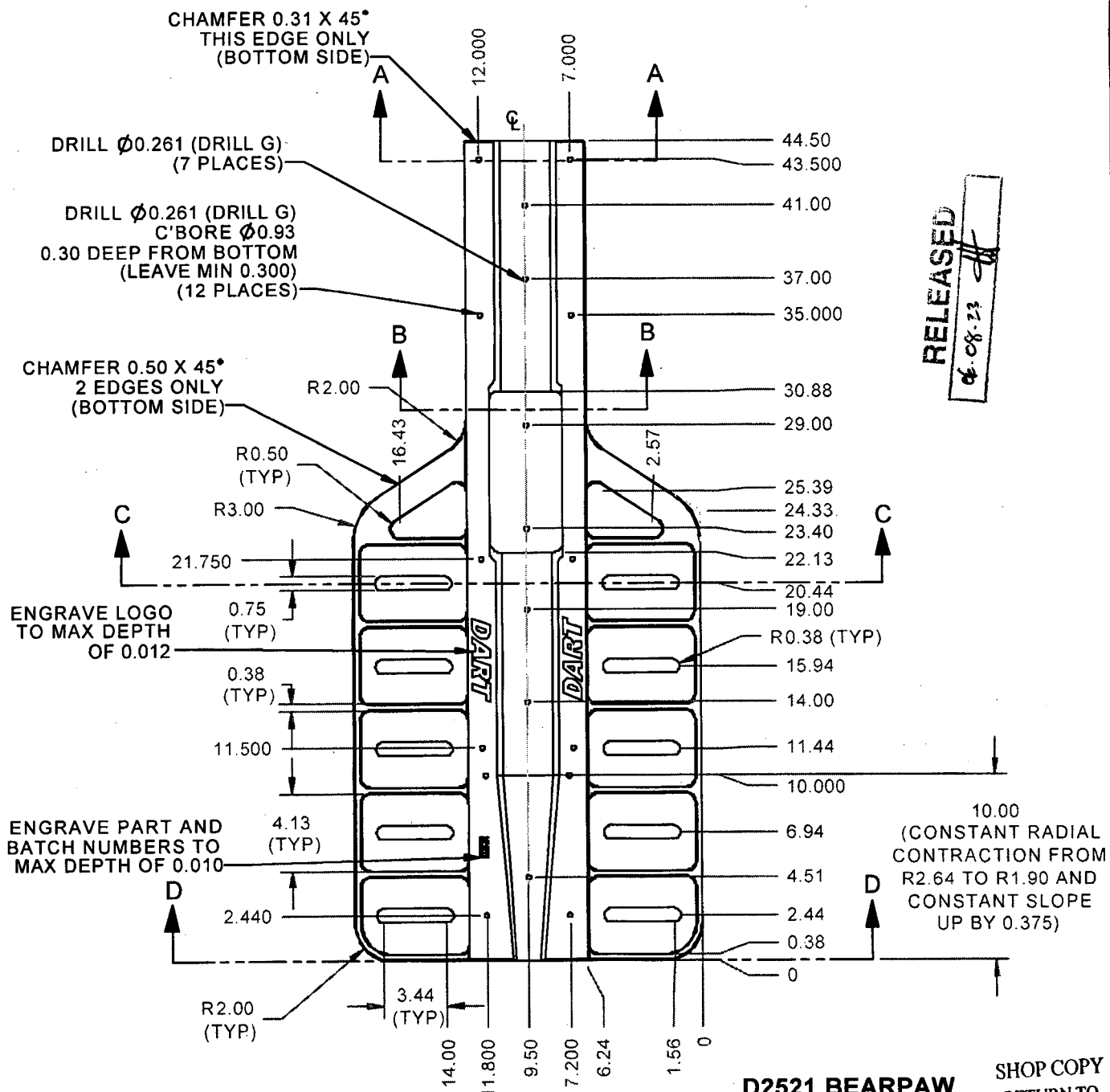
06 08.23 #

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DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED [Signature]	DRAWING NO. D2521	REV. J SHEET 2 OF 3
DATE 06.07.28	TITLE 205 BEARPAW	SCALE 1:8	

**NOTES:**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.030
- 6) PART IS SYMMETRIC ABOUT ϕ

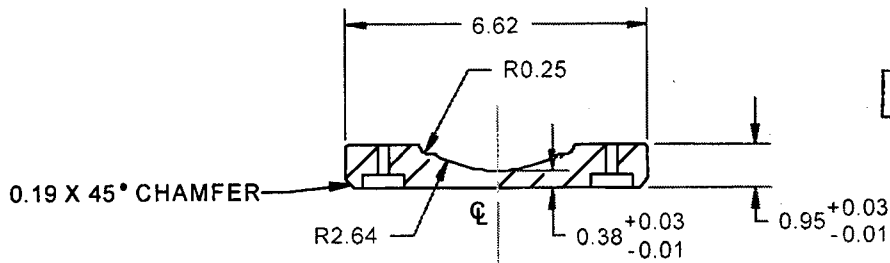
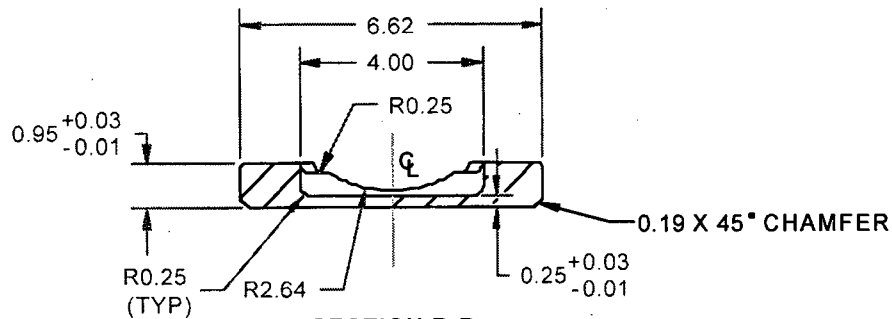
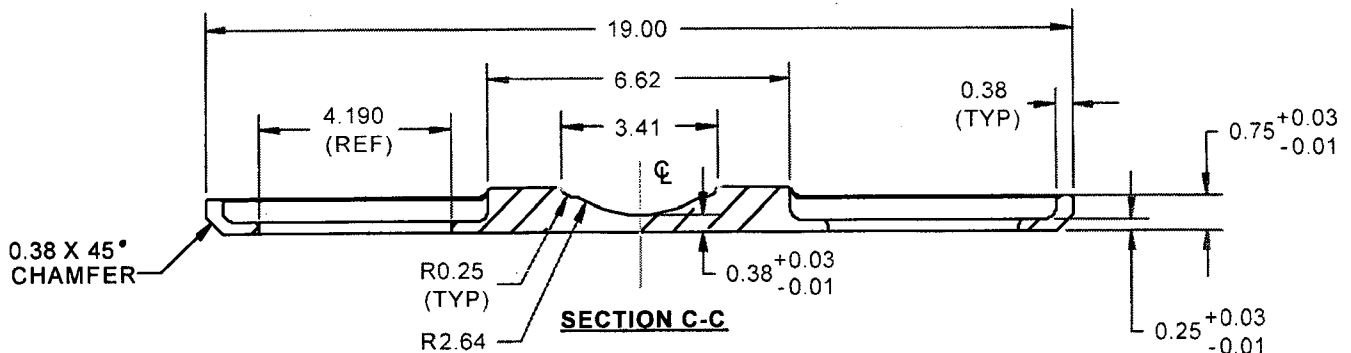
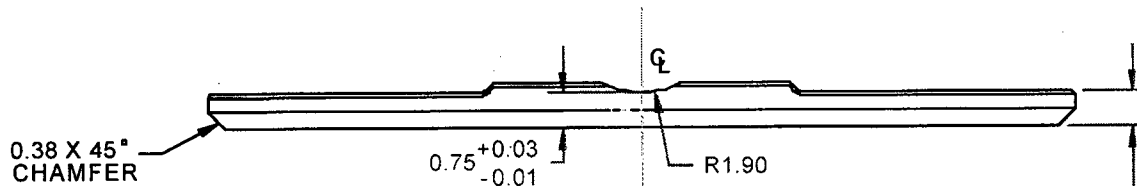
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NO. 41855

DART

DESIGN #	DRAWN BY C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED #	DRAWING NO. D2521	REV. J
DATE 06.07.28		TITLE 205 BEARPAW	SHEET 3 OF 3
			SCALE 1:4

**SECTION A-A****SECTION B-B****SECTION C-C****SECTION D-D****RELEASED**

06.08.23 #

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